

[illegible]

Page 1

Accept

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing whether the objectives have been met and identifying any lessons learned for future projects.

Setup Start

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

Stop

[illegible]**Cust Item ID:**

Required Date: 6/22/2011 **Req'd Qty:** 40.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Customer:

Reference:

Approvals:

Process Plan:

Date: 11/06/15

Tooling:

Date:

Run Start

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QC:


Date:

SPC (Y/N):

Date:

Stop

Abstract

100 0.00
 FLOW WATER JET
 Waterjet Memo 0.00 B11-6-29
 FLOW CNC Waterjet 1-Cut as per Dwg D2934 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
 (66) (28) Deburr if necessary LO

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the project.

3. The third step is to develop a plan or strategy to address the problem. This involves identifying the resources needed, the timeline, and the specific actions to be taken.

4. After the plan is developed, the next step is to implement the project. This involves putting the plan into action and monitoring progress along the way.

5. Finally, the project is evaluated to determine its effectiveness and impact. This involves comparing the results against the objectives and goals set at the beginning of the project.

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

QC8- Inspect parts - second check

0.00

Memo

0.00

Swivel 30





count
249



Work Order ID 70772




Wednesday, June 15, 2011 9:08:48 AM



Page 2

Item ID: D2934 Accept  Setup Start 
Revision ID:
Item Name: Saddle Spacer Stop 
Start Date: 6/15/2011 Start Qty: 40.00  Cust Item ID:
Required Date: 6/22/2011 Req'd Qty: 40.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00				49	0	BL	11-2-6
140  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							
150  Packaging	Identify as per dwg & Stock Location: <u>27</u>	0.00							
Packaging	Memo	0.00							

49x0 M/L 11/07/06

11/7/8 (492) S

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Page 3

Accept

Setup Start

Stop

[illegible]

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Cust Item ID:

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

00000000000000000000

QC

Memo

0.00

Quality Control

11/7/11 *[Signature]*
ME
11-07-08

Picklist Print

Wednesday, June 15, 2011 9:08:54 AM

Page 1

Work Order ID: 70772



Parent Item: D2934



Parent Item Name: Saddle Spacer



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A□00.06.06□New Issue□EC□
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 		Purchased	No			100	sf	256.5000	0.0318	1.338947	1.6		
6061-T6 .080 Sheet											1311-6-29		

Location

Loc Qty

Loc Code

MAT021

256.5

116268

33.5

117285

223

117285

(49)

DART AEROSPACE LTD		Work Order:	70722
Description: Saddle Spacer		Part Number:	D2934
Inspection Dwg: D2934 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.475	+/-0.010	.474	✓		V B02	
0.407	+/-0.010	.405	✓		V	
0.250	+0.030/-0.000	.266	✗		V	
R0.30	+/-0.030	.30	✓		R.G.	
Ø0.257	+0.005/-0.000	.260	✗		V	
0.784	+/-0.010	.783	✗		V	
0.826	+/-0.010	.824	✓		V	
R0.36	+/-0.030	.36	✓		R.G.	
0.080	+/-0.010	.077	✗		V	

Measured by: AB	Audited by: S	Prototype Approval:	N/A
Date: 11-6-09	Date: 11/06/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	08.08.27	0.080 dimension added	KJ/DD	AB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

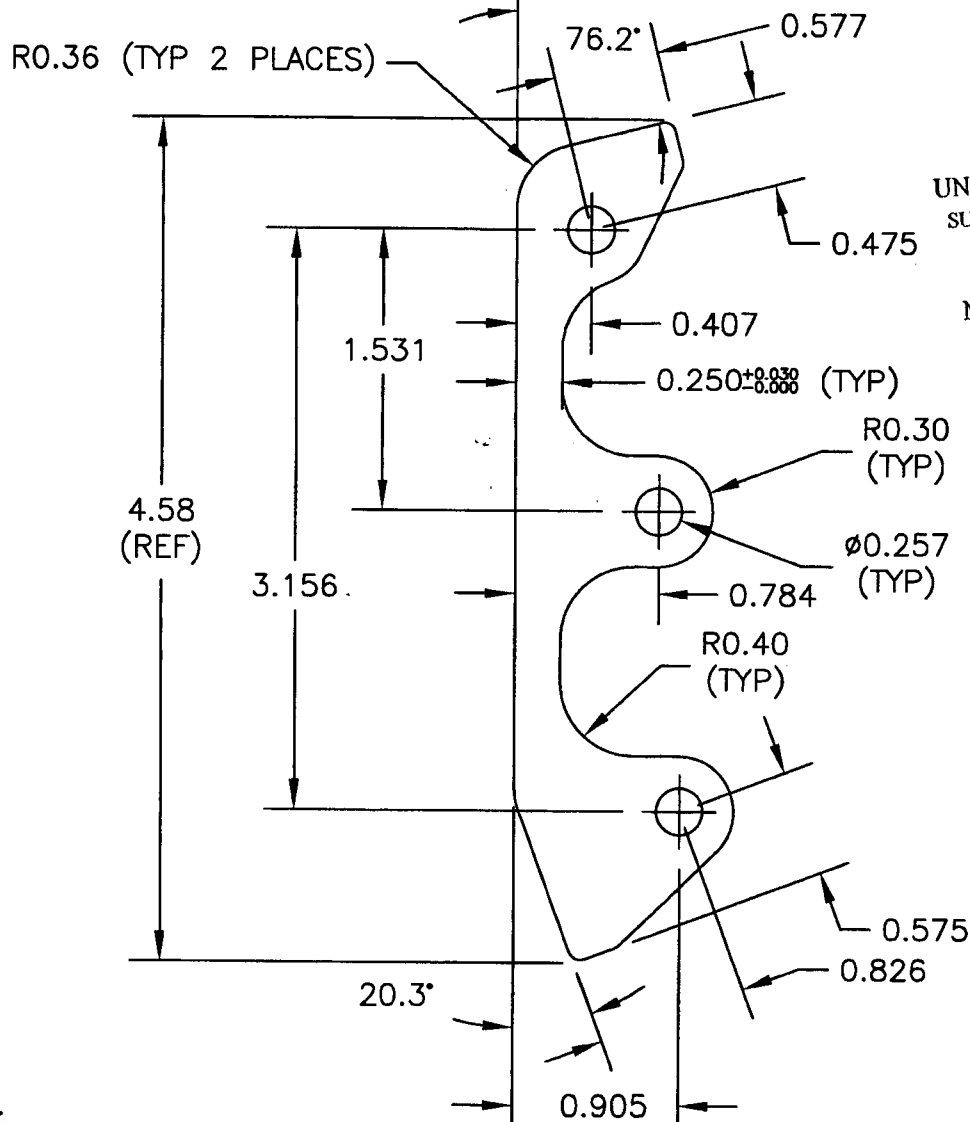
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN TH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**

06.06.20 [Signature]

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries